

M18147

Dart Aerospace Ltd.

Date: Tuesday, 21/10/2008 10:45:18 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLEVIS	
Job Number	: 42766		Part Number	: D37651	
Estimate Number	: 13301		Drawing Number	: D3765 REVA	
P.O. Number	:		Project Number	: N/A	
This Issue	: 21/10/2008 S.O. No. :		Drawing Revision	: A	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : MACHINED PARTS		Due Date	: 31/10/2008	
Previous Run	: 40971		Qty:	100	
Written By	:		Um:	Each	
Checked & Approved By	: JLD 08-10-21				
Comment	: Est Rev:A New Issue 08-05-05 JLM Verified By:EC Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6R1000	ROUND BAR 1.00" (no more mat M18147)
		Comment: Qty.: 0.1969 f(s)/Unit Total: 1.9688 f(s) ROUND BAR 1.00" $\Rightarrow$ 83 parts $\Rightarrow$ 17 ft Batch: M18147 $\Rightarrow$ 4 ft SA 08/11/17
2.0	DOOSAN LATHE	DOOSAN LATHE
		Comment: Doosan Lathe 1- Turn as per Folio FA744 Rev: N/A & Dwg D3765 Rev: A
		2-Deburr per dwg D3765
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE 1-SLIT PART USING 4" -7/32" WITH .063" RAD SLITTING SAW 2-DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	*						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/10/2008 10:45:18 AM  
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Drawing Name: CLEVIS

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Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE

N/A  
08/11/08

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0 QC8



SECOND CHECK



Comment: SECOND CHECK

08/11/08

(100)

7.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HS

08-11-08 X100

8.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MJ

08/11/08

9.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 24A A

S

08/11/08

X100

10.0 QC21



FINAL INSPECTION/W/O RELEASE



08/11/08 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/11/20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

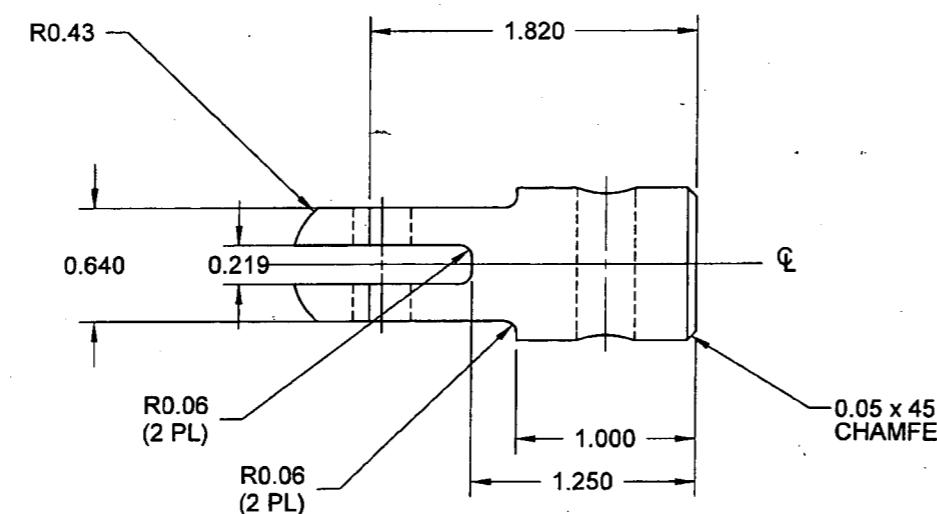
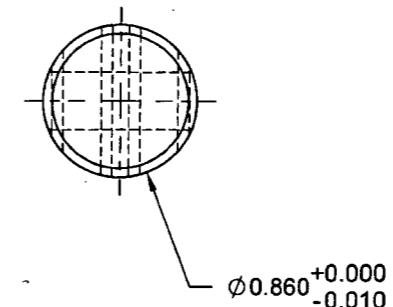
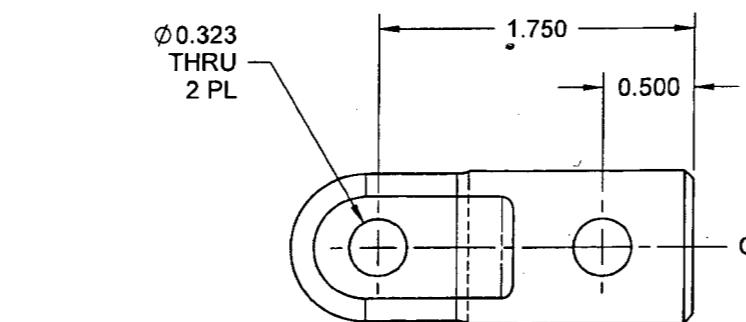
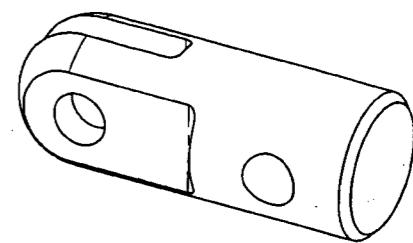
DART AEROSPACE LTD	Work Order:	42766
Description: Clevis	Part Number:	D3765-1
Inspection Dwg: D3765      Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## First Article      Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08/11/17	Date:	08/11/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	 



D3765-1 CLEVIS

**RELEASED**  
08.06.16 /WJD

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42700P

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PJ	DRAWING NO.	REV. A
MFG. APPR.	✓	D3765	SHEET 1 OF 1
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	CLEVIS	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs